

Work Order ID 99399

99399

Page 1

April-05-13 1:25:11 PM

Item ID: D2324-5

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Strap

Stop

NS2

Start Date: 4/04/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/19/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 1304-05

Tooling:

Date:

Run

Start

NR1

QC:

Date: _____

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2324	Rev C
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100	0.00
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100 FLOW WATER JET

Waterjet

Memo

0.00

12 0

B/JM3-6-7

FLOW CNC Waterjet

304 .063

I-Cut as per Dwg D2324 Dwg Rev: C Prog Rev: C 2-

Deburr if necessary

110	QC2- Inspect parts off machine FAI/FAIB	0.00
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110 QC

Quality Control

Memo

0.00

12 0

02 / JM3-6-7

120	QC8- Inspect parts - second check	0.00
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120 QC

Quality Control

Memo

0.00

12
B-6-7

NCR: Yes / No

DQA: Date:

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>		
				Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>		Quality <input type="checkbox"/>		
				Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>		
				Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>							
Centre Not Concentric to O/S	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>							
Cracks	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>							
Crushed/Crimped.	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>							
Cuffs	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>								
Heat Treat	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>								
Inspection Strip in Tube	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>								
Ripples in Bend	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>	Other <input type="checkbox"/>								
Torque Waves in Extrusion	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>									
Turning Sequence	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>									
Wave/Twist in Tube	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>									

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Page 2

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Cust Item ID:

Required Date: 4/19/13 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location

GP

0.00

130

Packaging

Packaging

Memo

0.00

DR

S
B67

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Quality Control

Memo

0.00

13/6/10

MF

B-6-10

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS														
			Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/>	Quality <input type="checkbox"/>	Other <input type="checkbox"/>
Part No. _____			Work Order Update <input type="checkbox"/>																	
NCR No. _____																				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description			Sign & Date	Verification	QC Inspector								
Doc/Data <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Operator <input type="checkbox"/> Material <input type="checkbox"/> Setup <input type="checkbox"/> Other <input type="checkbox"/> Process <input type="checkbox"/> Supplier <input type="checkbox"/> Training <input type="checkbox"/> Unapproved <input type="checkbox"/>																				
FAULT CATEGORY																				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/>	General																			
	Bend <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>																
	BOM/Route <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>																
	Broken/Damaged <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>																
	Burrs <input type="checkbox"/>	Instructions Incomplete/Unclear <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>																
	Contamination <input type="checkbox"/>	Maintenance <input type="checkbox"/>	Part Moved <input type="checkbox"/>																	
	Countersink <input type="checkbox"/>	Mislabeled <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>																	
	Cut Too Short <input type="checkbox"/>	Misread <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>																	
	Drill Holes <input type="checkbox"/>	Offset <input type="checkbox"/>	Other <input type="checkbox"/>																	
	Drawing <input type="checkbox"/>	Out of Calibration <input type="checkbox"/>																		
	Finish <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>																		
	Folio <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>																		

Picklist Print

Page 1

April-05-13 1:25:11 PM

Work Order ID: 99399**Start Date:** 4/04/13**Required Date:** 4/19/13**Parent Item:** D2324-5**Start Qty:** 6.00**Required Qty:** 6.00**Parent Item Name:** Strap**Comments:** IPP E03.02.28Reformat; Incorporated D2324-3 & D2324-5KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 304/316 Sheet .063		Purchased	No			100	sf	434.2073	0.0184	0.1104 0.25			EZ/JmB603

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	434.207264	
122245	0.1713688	
123136	140.8	
124428	44.7358952	
124572	248.5	

125599

125599

DQA: _____ Date: _____

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No. _____ NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other				

DART AEROSPACE LTD	Work Order:	99399
Description: Strut	Part Number:	D2324-5
Inspection Dwg: D2324	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	JM / <i>[initials]</i>	Audited by:	<i>[initials]</i>	Prototype Approval:	N/A
Date:	13-6-7	Date:	13-6-7	Date:	N/A

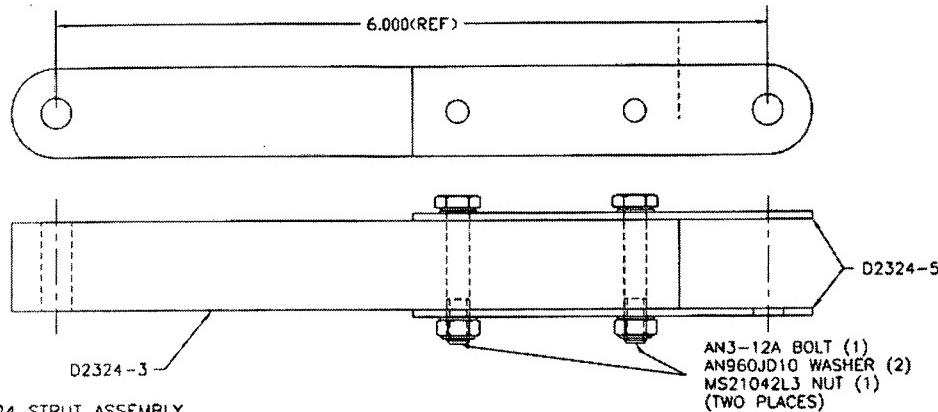
Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	SJM

DART

DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324
DATE 04.12.14	TITLE STRUT	REV. C SHEET 1 OF 1

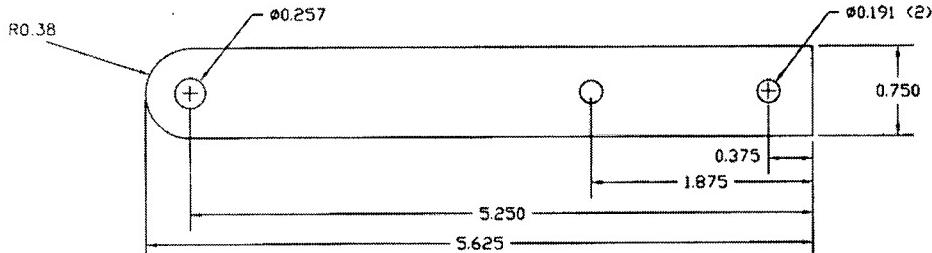
RELEASED

04.12.16 *[Signature]*



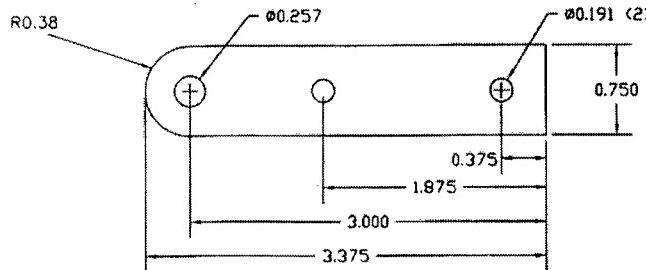
D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T680.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHK. C
K. TURNER
ENCLOSURE
UNCOMPLETED
SUBJECT TO REVISION
WITHIN 10 DAYS
NO. 99399 MUS
13-04-05